



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D350-636-015
Job Sheet 197907



Part No: D350-636-015

Job Qty: 1 pcs

Part Name: Skidtube LH, Run-on Landing Wearplates, DART(Apical) Cyllind./Aerazur Float Comp.

Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 7/18/19

Job Tracking No:

Due Date: 8/8/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG D4168-041 REV.C IPP rev:A 10.09.28 new issue DD verf:EC IPP Rev:B 11.04.14 ecn11-553 DD verf:EC IPP Rev:C 11.10.18 as per NCR 11-906 DD verf:EC IPP Rev:D 112.04.16 AS PER ECN 12-542 DD verf:EC IPP REV:E 13.08.28 PER ECN13-594 DD VERF:JLM IPP REV:F 18.11.12 AS PER DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Hrs	Run Hrs	Workcenter/Supplier	Lead Time	Sign-off
110	Skidtubes - 1	1 pcs	8/8/19		0.00	5.25	Skidtubes - 1		00
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	QC 10	1 pcs	8/8/19		0.00	0.00	QC 10 - 10		
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
							QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		

140 Handfinish - 1-1 Chemical-B4B	1 pcs	8/8/19	0.00 0.99	QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
150 QC 7	1 pcs	8/8/19	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
160 Skidtubes - 2 - B4B	1 pcs	8/8/19	0.00 5.25	Skidtubes - 1 - B4B	
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	

AUG 09 2019

BE

170 QC 10	1 pcs	8/8/19	0.00 0.00	Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
				QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	DAS SEP 03 2019 50
				QC 10 - 58	0.89
				QC 10 - 9	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	DAS SEP 03 2019 68
				QC 5 - 9	9-89
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
190 Handfinish - 2-1 Pressure- B4B	1 pcs	8/8/19	0.00 0.33	Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	SEP 04 2019
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
200 Spray Paint - 2 - B4B	1 pcs	8/8/19	0.00 0.91	Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	19-9-10
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
210 QC 14	1 pcs	8/8/19	0.00 0.00	QC 14 - 15	19-9-11
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	
				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
230 Handfinish - 4-1-Assembly- B4B	1 pcs	8/8/19	0.00 0.99	Handfinish - 4 - 1 - B4B	19-9-11
				Handfinish - 4 - 10 - B4B	
				Handfinish - 4 - 11 - B4B	
				Handfinish - 4 - 12 - B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	

Plex 7/18/19 10:40 AM Dart.lajeunesse.marie

240 QC 5	1 pcs	8/8/19	0.00 0.00	Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
250 Packaging 1-1 - Pick Kit - B4B	1 pcs	8/8/19	0.00 0.00	QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
				Packaging 1 - 1 - B4B	
				Packaging 1 - 2 - B4B	
				Packaging 1 - 3 - B4B	
				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	

DAS

40

SEP 20 2019

9-89

DAS

74

9-89

SEP 23 2019

260 QC 4	1 pcs	8/8/19	0.00 0.00	Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
				QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
				QC 4 - 75	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	1 pcs	8/8/19	0.00 0.00	DC - 1 - B4B	
				DC - 2 - B4B	
280 QC 21 - FG	1 pcs	8/8/19	0.00 0.00	QC 21 - FG - 21	
				QC 21 - FG - 70	
				QC 21 - SA - 53	

Max B.

9/23/2019

WC

SEP 23 2019

SEP 23 2019 70

Part Op 110 - 1- Pick D2600-3 Bent 2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg
Descriptions: D4168-1 3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill
then ream holes using 0.500" reamer. PIN first side. Repeat process on second side. ***ENSURE PROPER
POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE*** Drill pilot holes as per Dwg D4168
sheet 4 (D4168-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B) 4-

Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting, section H-H. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 5- Drill tow ring hole using DT9616 detail "A" 6- Drill most FWD wearplate hole using DT9678 locating off of 66.54" hole. 7- Open up holes of Detail A to 0.297" (total of 2 holes per side) and .201" (total of 1 hole per side using DT9616) 8- Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from bending as per QSI 004 A/R Aluminum Rod batch: 139011 9- Grind welds flush as per Dwg D4168

120 - QC10 (QC10- Inspect visual per QSI004- ground welds)
 130 - QC5 (QC5- Inspect part completeness to step on W/O)
 140 - HandFinish1 (Chemical Conversion Coat per QSI005 4.1)
 150 - QC7-2 (QC7-Inspect Chemical Conversion Coat)
 160 - (Skid tubes) 1-Open up holes using hole saw of Detail C and ground handling section AL-AL to 0.625" (total of 8 holes per side) as per dwg D4168. 2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side) as per dwg D4168. 3- Open float hole to 0.500" using uni-bit (4 per side) section AJ-AJ Open wearplate holes to size as per dwg (4 holes per sides) , section CG-CG 4-Chamfer holes of Detail B, C, ground handling section AL-AL and float holes section AJ-AJ per dwg D4168 (welding instructions on sheet 8) 5-Debur and blow out all chips from inside of tube 6-Prepare tube for welding, remove alodine as required. 7-Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 5174372 exp. date: 12/6/2019 ***ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8-Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 and D4170-1 & QSI004 (welding instructions on sheet 8) A/R Aluminum Rod batch: 139011 9- At section AJ-AJ drill out x-bolt spacer to 0.404" 10-Grind welds flush as per Dwg D4168 11-Spot face ground handling holes section (total of 4 places per side) as per dwg D4168, section AL-AL 12-C'bore section CG-CG. ADJUST TOOLING AS REQUIRED. VERF BY: _____ 13- Debur holes, ensure tube is free of all scratches before sending to paint.

170 - QC10 (QC10- Inspect visual per QSI004- ground welds)
 180 - QC5 (QC5- Inspect part completeness to step on W/O) ***VERIFY C'BOARD IS GOOD***
 190 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) HandFinish2 (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.
 200 - Spray Paint (Spray Paint / NDT Room) 1- PRIME AS PER DWG AND QSI 005 4.2.1.3.3 PRIMER PRC DESOTO 515X349 BATCH: 5200299 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5204428

210 - QC14 (QC14- Inspect Spray Paint) Inspect for foreign object per QSI 024
 230 - HandFinish4 (Assemble as per dwg) 1- Install inserts as per Dwg D4168 2-Inspect for Foreign Objects 3-Install blade fitting D3488-3, wearshoes and ground handling hardware as per dwg D4168 SIKA FLEX 241 BATCH: 5240625 EXP DATE: 2017-2 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: 5M138827 5-Coat all exposed fasteners with "LPS Procyon" batch: 4133690

240 - QC5 (QC5- Inspect part completeness to step on W/O)
 250 - Packaging1-3 (Pick Kit) If making a D350-636-215 pick kit will only requires: 1 X AN3C37A 1 X AN3C34A 1 X AN3C42A 2 X D3493-1
 260 - QC4 (QC4- 100% Inspect kits for completeness)*****ensure antiseize is on AN8C21A bolts*****
 270 - Packaging3-1 (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPPD350-636-015 Location :FG071
 275 - DC (Document Control) record fwd angle: 89.9 Photocopy blue file and type labels per PPP D350-636-015 CHG 006
 280 - QC21 (QC21- Final Inspection - Work Order Release)

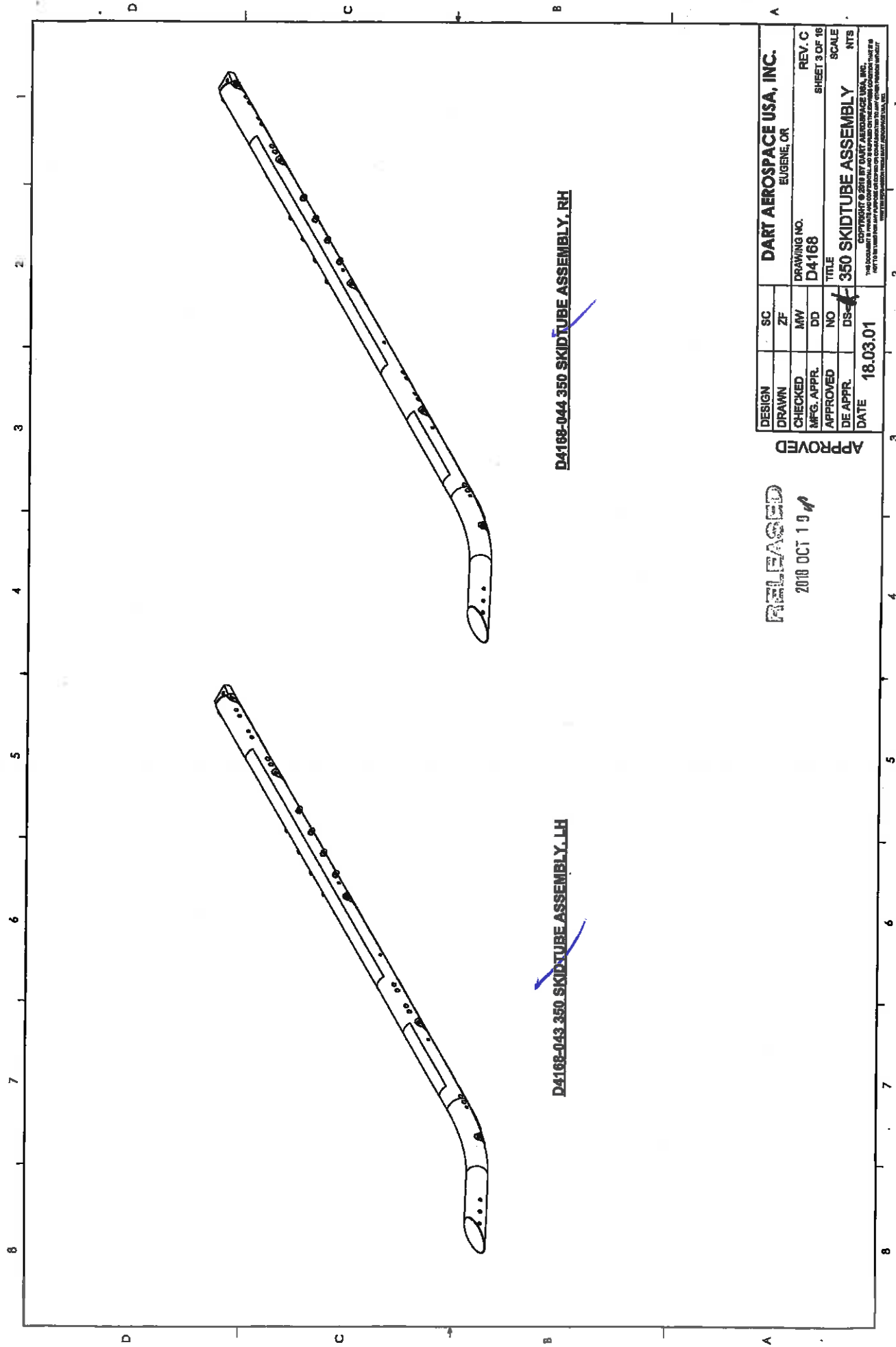
Job BOM				011858
Part / Item	Component Name	Quantity	Operation	Container
D2600-3-BENT-LH	Extrusion Bent LH	1 pcs (1 ea)	110-Skidtubes - 1	5192857
D2744	Cap	1 pcs (1 ea)	110-Skidtubes - 1	5192776
D2739	350 I-Beam	1 pcs (1 ea)	160-Skidtubes - 2 - B4B	5204977
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skidtubes - 2 - B4B	5194932
D3490-1	Cross Bolt Spacer	4 pcs (4 ea)	160-Skidtubes - 2 - B4B	5186299
D3490-3	Cross Bolt Spacer	4 pcs (4 ea)	160-Skidtubes - 2 - B4B	5186611
ALS4-1032-225	Rivnut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5174308
AN3C34A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5186091
AN3C36A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5167187
AN3C6A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5167048
AN6C44A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5160263
AN8C35A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5206359
D2745	Bushing	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5184452
D3488-3	Blade Fitting, LH	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5184405
D3492-1	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5205435
D3492-3	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5184192
D3631-1	Washer	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5209431
D3873-1	Bushing	7 pcs (7 ea)	230-Handfinish - 4-1-Assembly-B4B	5195274
D4154-041	Wearplate Assembly	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5180791
D4170-1	Bushing	4 pcs (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5175928
D4171-1	Bushing	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5099565
MS21043-3	Nut	5 Ea (5 ea)	230-Handfinish - 4-1-Assembly-B4B	5166969
MS21043-6	Nut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5167203-1
MS21083C8	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5193136
NAS1149C0332R	Washer (AN960C10L)	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5135100
NAS1149C0363R	Washer (AN960C10)	9 Ea (9 ea)	230-Handfinish - 4-1-Assembly-B4B	5076017-3
NAS1149C0832R	Washer (AN960C816L)	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B	5083565
NAS1515H3L	Washer	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B	5057564
NAS1611-010	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	5170274
NAS1611-013	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B	51138009-2
AN3C37A	Bolt	1 Ea (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5168418
AN3C42A	Bolt	1 Ea (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5108570
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5184404
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	5197603
D3493-1	Washer	2 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5194486
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5215806
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	5166718

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2600-3-BENT-LH	1	9	0
	D2744	1	48	0
	D2739	1	12	0
160-Skidtubes - 2 - B4B	D2743	8	255	0
	D3490-1	4	153	0
	D3490-3	4	46	0
	ALS4-1032-225	4	835	0
	AN3C34A	1	40	0
230-Handfinish - 4-1-Assembly-B4B	AN3C36A	4	255	0
	AN3C6A	4	149	0
	AN6C44A	4	122	0
	AN8C35A	1	30	0
	D2745	8	64	0
	D3488-3	1	12	0
	D3492-1	8	67	0
	D3492-3	8	23	0
	D3631-1	8	376	0
	D3873-1	7	42	0
	D4154-041	1	12	0
	D4170-1	4	49	0
	D4171-1	1	26	0
	MS21043-3	5	934	0
	MS21043-6	4	99	0
	MS21083C8	1	93	0
	NAS1149C0332R	4	4,430	0
	NAS1149C0363R	9	695	0
	NAS1149C0832R	1	294	0
	NAS1515H3L	4	181	0
	NAS1611-010	8	219	0
	NAS1611-013	8	116	0
250-Packaging 1-1 - Pick Kit - B4B	AN3C37A	1	119	0
	AN3C42A	1	49	0
	AN8C21A	2	121	0
	D2741	1	56	0
	D3493-1	2	17	0
	MS21083C8	2	93	0
	NAS1149D0863J	2	375	0

Part Specifications

Specifications could not be found.

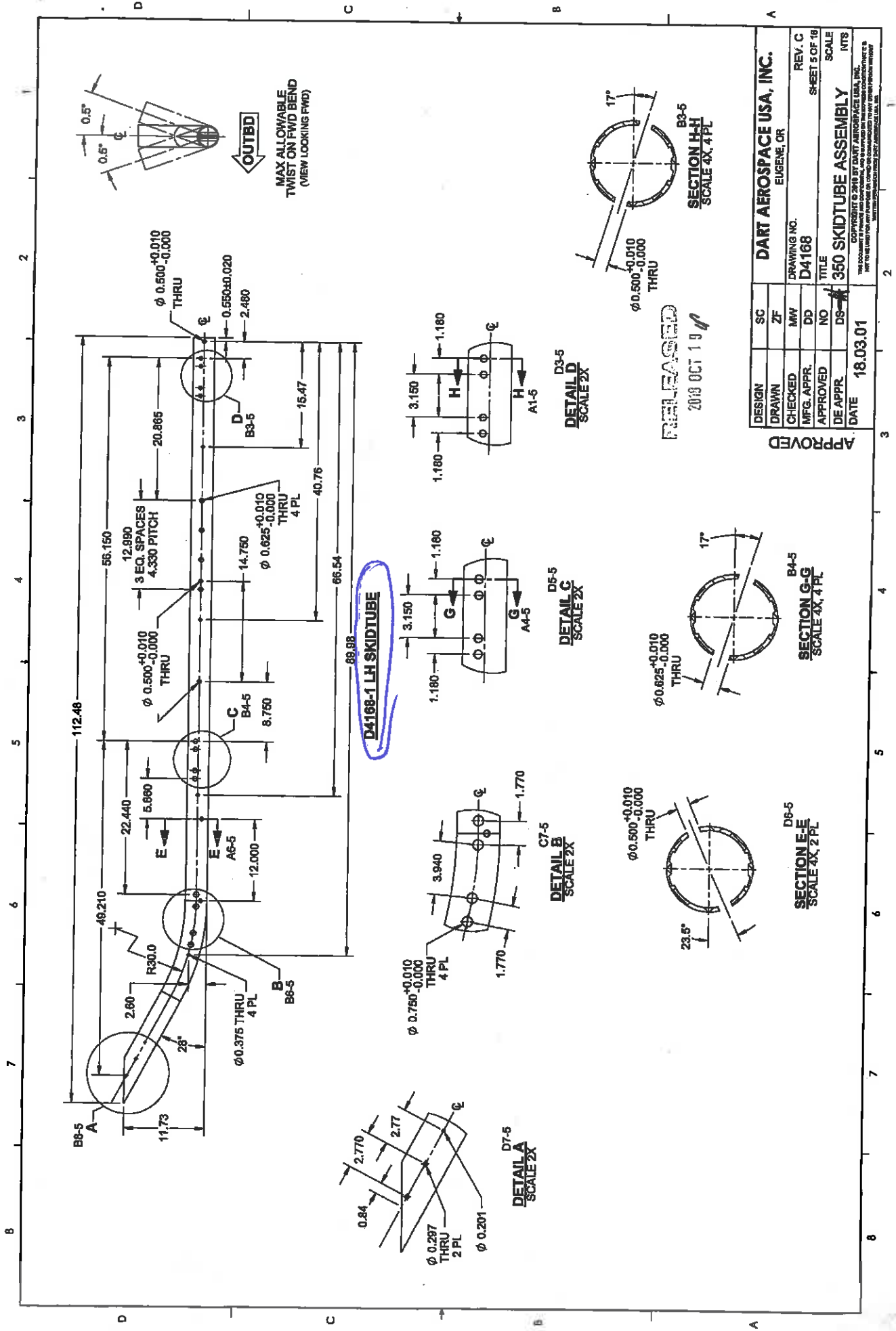
Plex 7/18/19 10:40 AM Dart.lajeunesse.marie



RELEASED
2010 OCT 19 40

DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE, OR	
CHECKED	MW	DRAWING NO.	REV. C
MFG. APPR.	DD	D4168	SHEET 3 OF 16
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.01		

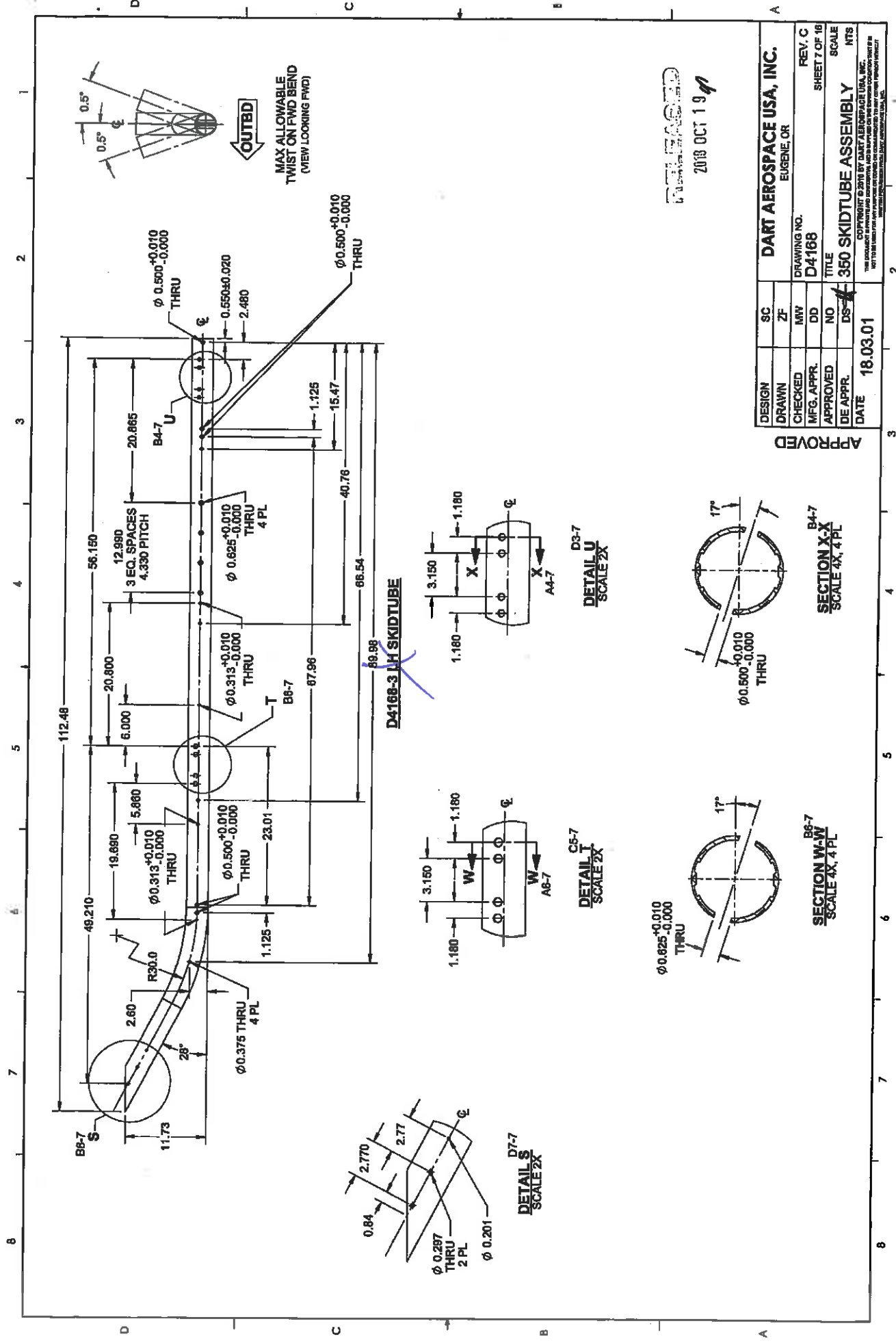
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DART AEROSPACE USA, INC.			
DESIGN	SC	EUGENE, OR	REV. C
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CHECKED	MW		
MFG. APPR.	DD		
APPROVED	NO		
DE APPR	DS		
DATE	18.03.01		

APPROVED

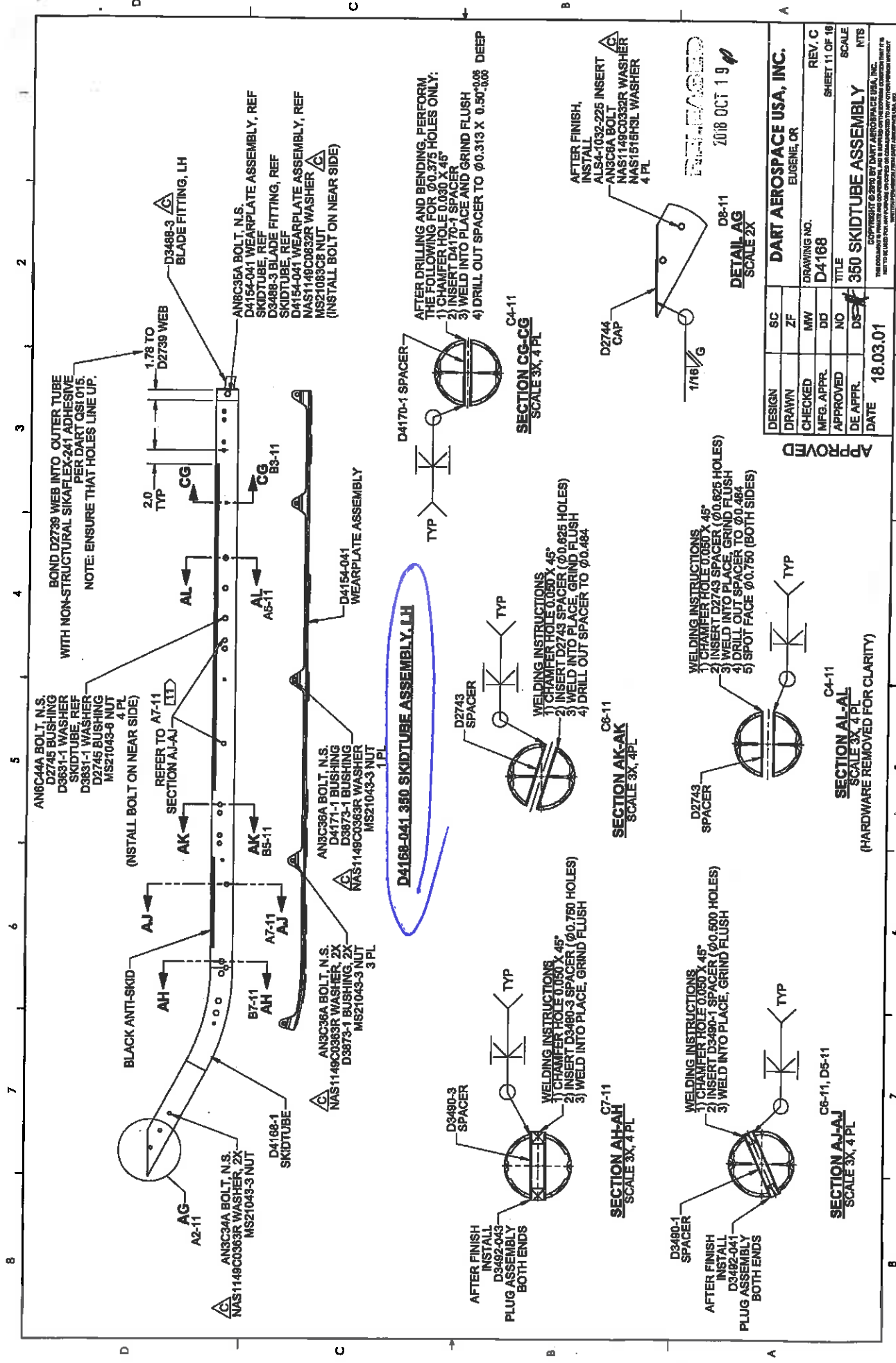
350 SKIDTUBE ASSEMBLY			
SCALE	NTS		
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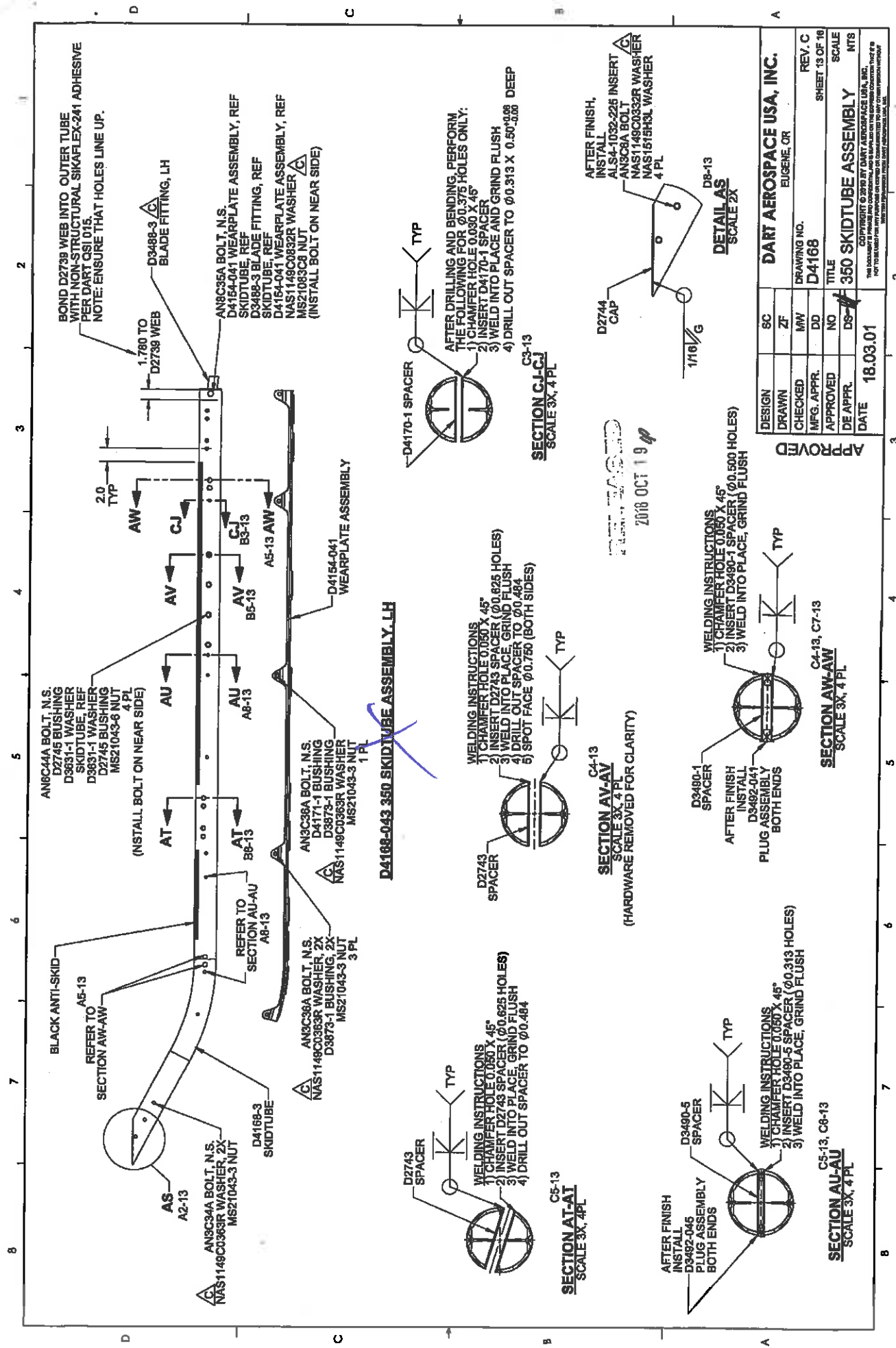
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2019 OCT 19 *af*

DESIGN	SC	DART AEROSPACE USA, INC. EUGENE, OR DRAWING NO. D4168 REV. C SHEET 7 OF 18 SCALE 360 SKIDTUBE ASSEMBLY NTS COPYRIGHT © 2018 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS UNCLASSIFIED AND AVAILABLE TO THE GENERAL PUBLIC WITHOUT FEE. ALL RIGHTS RESERVED. NO PART OF THIS DOCUMENT MAY BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.
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MFG. APPR.	DD	
APPROVED	NO	
DE APPR.	DS- 1	
DATE	18.03.01	

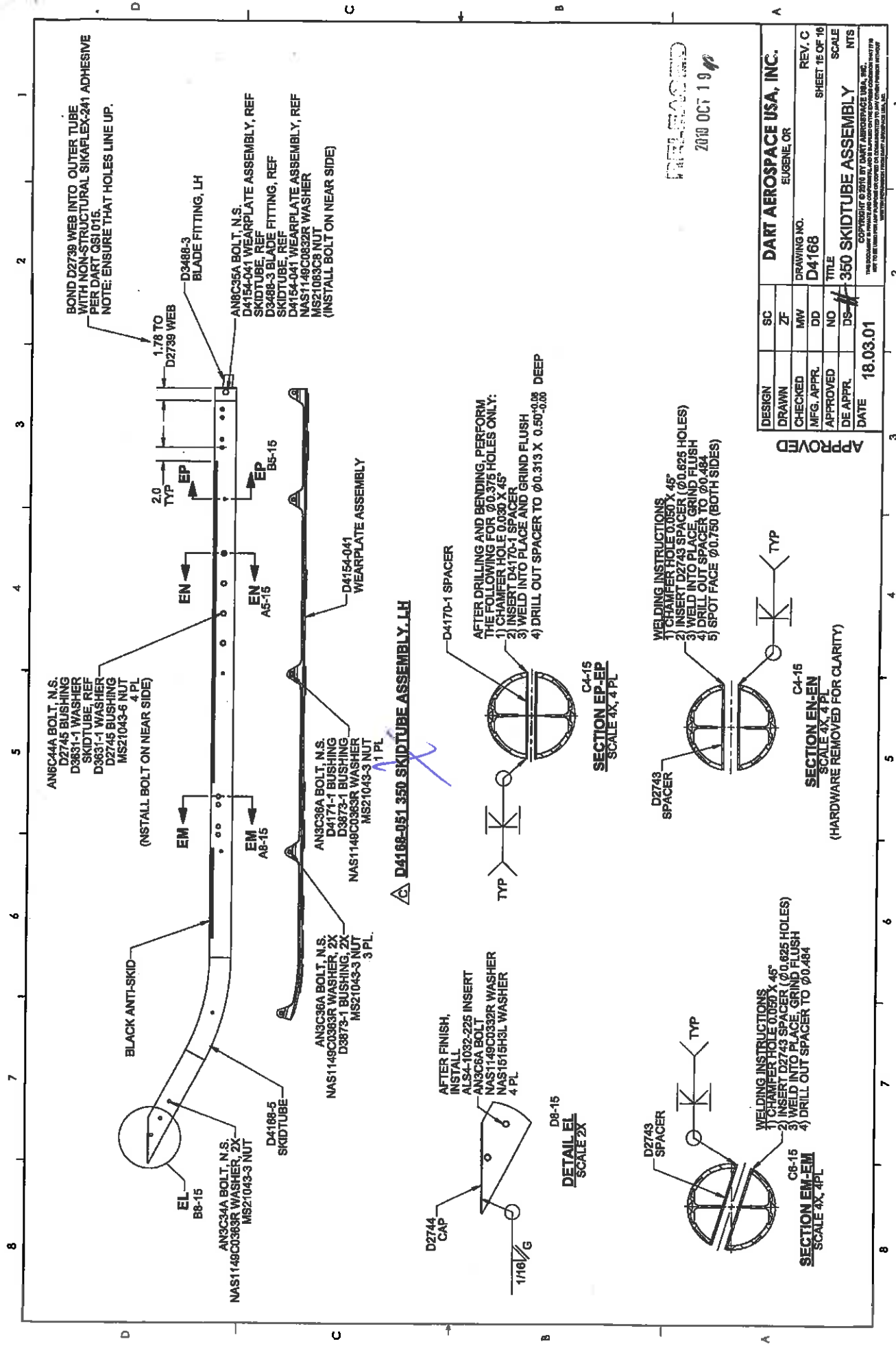


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MFG. APPR.	DD	D4188
APPROVED	NO	TITLE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY
DATE	18.03.01	REV. C SHEET 11 OF 10
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MFG. APPR.	DD			
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DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS	
DATE	18.03.01			

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NCR No. _____		Job: _____		Part No. _____		DISPOSITION		DEPARTMENT/PROCESS		MRB (QS1042)	
Date : _____		Sequence #:		QTY Affected :		Rework Scrap Use-as-is		Cross tube Small Fab Finishing		Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging	
Description Work Order Deviation		Disposition		Completed By		Lead hand / Supervisor		QC / QA Coordinator		Engineering Water Jet Supplier Quality	
Root Cause		FAULT CATEGORY		Other/Details:		Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread		Power Loss/Surge Follo/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up			
Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled		Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function		Power Loss/Surge Follo/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up					

7.0 PARTS LIST

D350-636-015/-016/-017/-018 SKIDTUBES AT CHG 006 AND SUBSEQUENT

D350-636-023/-024 SKIDTUBES AT CHG 001 AND SUBSEQUENT

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -023	Qty -024	Qty -047	Part Number	Description
	X							D350-636-015	SKIDTUBE INSTALLATION, LH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
		X						D350-636-016	SKIDTUBE INSTALLATION, RH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE W/TRAINING WEARPLATE
			X					D350-636-017	SKIDTUBE INSTALLATION, LH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
				X				D350-636-018	SKIDTUBE INSTALLATION, RH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE W/TRAINING WEARPLATE
					X			D350-636-023	SKIDTUBE INSTALLATION, LH, STD COMPATIBLE W/TRAINING WEARPLATE
						X		D350-636-024	SKIDTUBE INSTALLATION, RH, STD COMPATIBLE W/TRAINING WEARPLATE
							X	D350-636-047	TRAINING WEARPLATE KIT (LH/RH)
1	1							D4168-041	SKIDTUBE ASSEMBLY, LH
1		1						D4168-042	SKIDTUBE ASSEMBLY, RH
1			1					D4168-043	SKIDTUBE ASSEMBLY, LH
1				1				D4168-044	SKIDTUBE ASSEMBLY, RH
1					1			D4168-051	SKIDTUBE ASSEMBLY, LH
1						1		D4168-052	SKIDTUBE ASSEMBLY, RH
*1	1							D4168-1	SKIDTUBE WELDMENT, LH
*1		1						D4168-2	SKIDTUBE WELDMENT, RH
*1			1					D4168-3	SKIDTUBE WELDMENT, LH
*1				1				D4168-4	SKIDTUBE WELDMENT, RH
*1					1			D4168-5	SKIDTUBE WELDMENT, LH
*1						1		D4168-6	SKIDTUBE WELDMENT, RH
**2	8	8	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8	8	8		22541N120	NUT
*5	1	1	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1	1	1		NAS1149CO832R	WASHER
*7	1	1	1	1	1	1		MS21083C8	NUT
*8	1		1		1			D3488-3	BLADE FITTING, LH
*8		1		1		1		D3488-4	BLADE FITTING, RH
9	1	1	1	1	1	1		D2741	BLADE
10	2	2	2	2	2	2		AN8C21A	BOLT
11	2	2	2	2	2	2		NAS1149CO863J	WASHER
12	2	2	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8	8	8		D2745	BUSHING
*16	4	4	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4	4	4		NAS1149CO332R	WASHER
*20B	4	4	4	4	4	4		NAS1515H3L	WASHER

Item	Qty -015	Qty -016	Qty -017	Qty -018	Qty -023	Qty -024	Qty -047	Part Number	Description
*30	8	8	8	8				D3492-041	PLUG ASSEMBLY
*31	8	8						D3492-043	PLUG ASSEMBLY
*32			8	8				D3492-045	PLUG ASSEMBLY
***43	2	2	2	2				D3493-1	WASHER
*90	1	1	1	1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
*91A	4	4	4	4	4	4	4	AN3C36A	BOLT ¹
91B	1	1	1	1	1	1	1	AN3C37A	BOLT ²
91C	1	1	1	1			1	AN3C42A	BOLT ³
*92	7	7	7	7	7	7	8	NAS1149CO363R	WASHER
92A			1	1				NAS1149CO363R	WASHER ³
*93	4	4	4	4	4	4	4	MS21043-3	NUT
*94	7	7	7	7	7	7	8	D3873-1	BUSHING
94A			1	1				D3873-1	BUSHING ³
*95	1	1	1	1	1	1	1	D4171-1	BUSHING ⁴
96							4	D4170-3	SPACER
*97	1	1	1	1	1	1	1	AN3C34A	BOLT
*98	2	2	2	2	2	2	2	NAS1149CO363R	WASHER
*99	1	1	1	1	1	1	1	MS21043-3	NUT

* PART OF D4168-041/-042/-043/-044/-051/-052
** TO BE SUPPLIED BY CUSTOMER
*** ONLY INSTALLED IF INSTALLING A DART FLOAT SYSTEM

¹ QTY USED MAY BE LESS ON SKIDTUBES WITH DART CYLINDRICAL OR TRI-BAG FLOATS
² HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART CYLINDRICAL BAG FLOATS
³ HARDWARE USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS
⁴ HARDWARE NOT USED ON THE SKIDTUBES INSTALLED WITH DART TRI-BAG FLOATS

Change Record

PAGE 1 OF 1

Part Number: D350-636-015/-016

Description: SKIDTUBE STD LH/RH w/ TRAINING WEARPLATE

[illegible]